

## CLAIMS

1. (Previously presented) A folding carton comprising:

a blank in a folded configuration to define an interior space for receiving contents, and having an interior surface containing printed material;

said folded blank defining a contents access opening and including a contents access flap closing said contents access opening, said flap being movable to provide access to the contents of the carton; and

a manufacturer's joint securing said blank in said folded configuration and being peelable to permit unfolding of said blank to an open position that exposes said printed material, said manufacturer's joint comprising:

a first panel having a thickness and a surface, said first panel including a plurality of punch scores in said surface of said first panel, said punch scores extending only partially through said thickness;

a second panel disposed adjacent to said first panel, said second panel including a surface facing said surface of said first panel, said surface of said second panel being at least partially coated with a coating material and including a plurality of knock-outs, said knock-outs defined by an absence of any coating material, said knock outs being aligned with said punch scores; and

an adhesive disposed between said first panel and said second panel adhesively joining said first panel and said second panel, said adhesive disposed in alignment with said

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punch scores and said knock-outs whereby said adhesive directly adheres to said surface of said second panel in the location of said knock-outs.

2. (Original) The carton of claim 1 further defining an uncoated stripe running through said knockouts on said second panel.
3. (Previously presented) The carton of claim 1 further including a coating material on said surface of said first panel.
4. (Original) The carton of claim 3 further defining an uncoated stripe running through said punch scores on said first panel.
5. (Original) The carton of claim 4 wherein said adhesive is a water-based adhesive.
6. (Original) The carton of claim 4 wherein said first panel is an adhesive panel and said second panel is a right panel.
7. (Original) The carton of claim 6 further including a front panel hingedly attached to said right panel, a left panel hingedly attached to said front panel and a back panel hingedly attached to said left panel and said adhesive panel.
8. (Previously presented) The carton of claim 7, said contents access opening comprising said contents access flap hingedly attached to said front panel and a second closure flap hingedly attached to said back panel, each of said flaps hingedly attached to a locking tab.
9. (Original) The carton of claim 8 further including a plurality of dust flaps hingedly attached to each of said right panel and said left panel.

10. (Previously presented) The carton of claim 9 further including an exterior surface, and a coating on said interior surface and said exterior surface, wherein said coating is a protective coating.

11. (Original) The carton of claim 10 wherein said coating is a UV varnish.

12. (Original) The carton of claim 4 wherein each of said punch scores penetrates approximately  $\frac{1}{2}$  said thickness of said adhesive panel.

13. (Original) The carton of claim 12 wherein the coating is a UV varnish.

14. (Previously Presented) A carton blank for folding into a carton comprising:

a first panel having a surface, said surface of said first panel being at least partially coated with a coating material and including a plurality of knock outs, said knockouts defined by an absence of said coating material;

a second panel having a thickness and a surface, said second panel at least partially coated with a coating material, said second panel including a plurality of punch scores in said surface of said second panel, said punch scores extending only partially through said thickness, said punch scores being configured to align with said knockouts when said blank is folded to form a carton;

an uncoated stripe on said first panel or said second panel, said stripe defined by an absence of said coating and extending through said knock outs on said first panel or said punch scores on said second panel; and

an adhesive for securing said first panel to said second panel when said blank is folded to form the carton, said adhesive directly adhering to said surface of said first panel in the location

of said knock-outs and to said first panel or said second panel in the location of said uncoated stripe.

15. through 17. (Canceled)

18. (Original) The carton blank of claim 14 wherein said punch scores penetrate approximately  $\frac{1}{2}$  said thickness of said second panel.

19. (Original) The carton blank of claim 18, wherein said first panel is a right panel and said second panel is an adhesive panel.

20. (Original) The carton blank of claim 19 further including a front panel hingedly attached to said right panel, a left panel hingedly attached to said front panel and a back panel hingedly attached to said left panel and said adhesive panel.

21. (Original) The carton blank of claim 20 further including a first closure flap hingedly attached to said front panel, a second closure flap hingedly attached to said back panel, a first locking tab hingedly attached to said first closure flap, and a second locking tab hingedly attached to said second closure flap.

22. (Original) The carton blank of claim 21 further including a plurality of dust flaps hingedly attached to each of said right panel and said left panel.

23. (Withdrawn) A method of making a carton, comprising the steps of:

(a) producing a carton blank having a first panel and a second panel, the first panel having a surface, the second panel having a surface, and the first panel having a thickness;

(b) forming punch scores on the surface of the first panel;

(c) forming knock outs on the surface of the second panel; and

(d) folding the blank into a carton with the surface of the first panel engaging the surface of the second panel, whereby the punch scores are aligned with the knock outs.

24. (Withdrawn) The process of claim 23 further including the step of applying an adhesive to at least one of the surface of the first panel and the surface of the second panel.

25. (Withdrawn) The process of claim 24 further including the step of applying an adhesive to the surface of the first panel in a line through the punch scores.

26. (Withdrawn) The process of claim 23 further including the step of applying an adhesive to the surface of the second panel in a line through the knock outs.

27. (Withdrawn) The process as in claim 26 wherein said step of forming knock outs is carried out with a printing press, the printing plate of the printing press defining the knock outs when applying a coating.

28. (Withdrawn) The process as in claim 27 wherein said step of forming punch scores is carried out with a punch.

29. (Withdrawn) The process as in claim 27 wherein said step of forming punch scores is performed by a punch that penetrates approximately  $\frac{1}{2}$  the thickness of the first panel.

30. (Withdrawn) The process of claim 23 wherein the first panel is an adhesive panel and the second panel is a right panel.

31. (Withdrawn) The process of claim 30 further including the step of producing a front panel, a left panel, and a back panel on the carton blank.

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32. (Withdrawn) The process of claim 31 wherein said step of folding the carton includes the steps of:

- (i) placing the blank with the surface of the right panel facing up;
- (ii) folding the right panel and left panel upward;
- (iii) folding the back panel downward until it contacts the right panel;
- (iv) folding the adhesive panel downward so the surface of the adhesive panel contacts the surface of the right panel and each knockout on the right panel is coincident with one punch score on the adhesive panel;
- (v) attaching the surface of the adhesive panel to the surface of the right panel.

33. (Withdrawn) The process of claim 32, further including the step of producing two dust flaps on each of the right panel and left panel and one closure flap on each of the front panel and back panel of the carton blank, each closure flap being produced with one locking tab.

34. (Withdrawn) The process of claim 33, wherein said step of folding the carton further includes the steps of:

- (vi) folding the dust flaps on the right panel toward the left panel;
- (vii) folding the dust flaps on the left panel toward the right panel;
- (viii) folding the closure flap on the front panel toward the back panel until it contacts the back panel;
- (ix) folding the closure flap on the back panel toward the front panel until it contacts the front panel;

(x) folding the locking tab of the closure flap on the front panel under the back panel; and

(xi) folding the locking tab of the closure flap on the back panel under the front panel.

35. (Currently Amended) A folding carton comprising:

a contents access opening including a contents access flap closing said contents access opening, said flap being movable to provide access to the contents of the carton;

a manufacturer's joint securing said carton in a folded configuration and being peelable to permit unfolding of said carton to an open position, said manufacturer's joint comprising:

an adhesive panel having a thickness and a surface, said adhesive panel including a plurality of punch scores in said surface of said adhesive panel, said punch scores extending only partially through said thickness;

a knock-out panel disposed adjacent to said adhesive panel, said knock-out panel including a surface facing said surface of said adhesive panel, said surface of said knock-out panel being at least partially coated with a coating material and including a plurality of knock-outs, said knock-outs defined by an absence in said coating material, said knock-outs being aligned with said punch scores; and

an adhesive disposed between said adhesive panel and said knock-out panel adhesively joining said adhesive panel and said knock-out panel, said adhesive aligned with said punch scores and said knock-outs, said adhesive disposed in a continuous line extending substantially

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across said adhesive panel along said punch scores and said knock-outs so that the adhesive directly adheres to said knock-out panel at said knock-outs.